

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023656**Date Inspected:** 10-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Subhasis Bera was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

In process Inspection

Trial Assembly Area

This QA Inspector observed the following work in progress:

SMAW in the 4G position for OBG segment 13BE, welding of weld No. CA3013-001.The Welder is identified as 067572. ZPMC Quality Control is identified as Mr. Liu Hua Jie . The welding variables recorded by QC personnel appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1. The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 4G position for OBG segment 13AE, welding of weld No. SEG3007AB-095.The Welder is identified as 067572. ZPMC Quality Control is identified as Mr. Liu Hua Jie . The welding variables recorded by QC personnel appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1. The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 3G position for OBG segment 13CE, welding of UT repair weld No. SEG3011L-218.The Welder is identified as 068924. ZPMC Quality Control is identified as Mr. Liu Hua Jie . The welding variables recorded by

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QC personnel appeared to comply with WPS-345-SMAW-3G(3F)-FCM-REPAIR-1. The weld repair report is identified as WR17632. The In-process SMAW appears to be progressing in compliance with approved contract documents.

Ultrasonic Testing (UT) at Bay#11

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as Tower weld joints.

The weld designations reviewed are as follows:

WSD1-TBSA7-4B/B -13,24

ESD1-TBSA7-4B/B-13,24

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Dsouza,Christopher	QA Reviewer
